Work Order ID 110127

110127

December-17-13 9:15:43 AM

Item ID: D4799-1 D4799-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: B110127 **Stop** *NS2*

Item Name: Clamp

Start Date: 12/17/13 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 12/17/13 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-12-19 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4799 / B									
100		0.00							
100						22	0	13-12-31	
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						22	0	13-12-31	
QC	**Memo**	0.00							
Quality Control									

Item ID: D4799-1 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Clamp
Start Date: 12/17/13 **Start Qty:** 8.00 *8* **Cust Item ID:**
Required Date: 12/17/13 **Req'd Qty:** 8.00 *8* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(22)	B-12-31	PD	
120									
QC	**Memo**	0.00							
Quality Control									
130	Form as per dwg	0.00		DAS 30 9-89		22			12/01/07
130									
Brake NC	**Memo**	0.00							
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00		DAS 27 9-89		20			
140									
QC	**Memo**	0.00							
Quality Control									

14/1/7

Item ID: D4799-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Clamp
Start Date: 12/17/13 **Start Qty:** 8.00 *8*
Required Date: 12/17/13 **Req'd Qty:** 8.00 *8*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: ST457	0.00							
150									
Packaging	**Memo**	0.00				22x	DAS 28 9-89	14-01-7	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00						14-01-8	
Quality Control									

08/01/2014

14-01-8

Picklist Print

December-17-13 9:15:42 AM

Work Order ID: 110127

Parent Item: D4799-1

Parent Item Name: Clamp

Start Date: 12/17/13 **Required Date:** 12/17/13

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A NEW ISSUE 13-03-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No				sf	131.4500		**0.5894736** EL 13-12-31			

Location	Loc Qty	Loc Code	
MAT020	131.45		
117933	4.5		
119276	9.7		
M126075	117.25		1.8

DART AEROSPACE LTD	Work Order:	110127
Description: clamp	Part Number:	D4799-1
Inspection Dwg: D4799 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.257	$\pm^{0.006}_{0.001}$	.258	✓	✓	JKMOS	
0.75	+/- 0.03	0.758	✓			
1.00	+/- 0.03	1.013	✓			
9.16	+/- 0.03	9.15	✓		JKMOS	
8.412	+/- 0.01	8.419	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	13-12-31	Date:	13-12-31	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

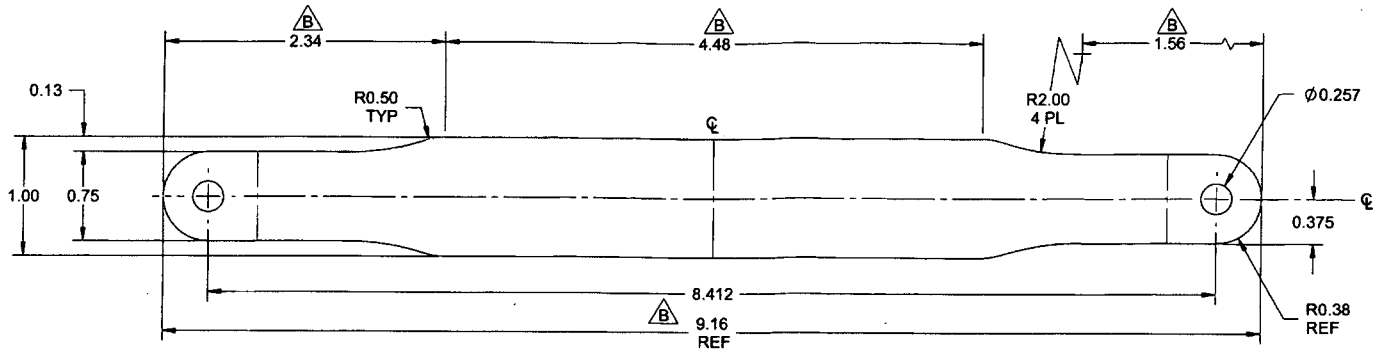
Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

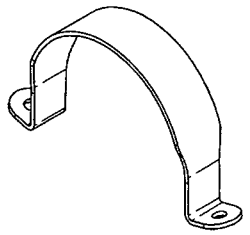
General

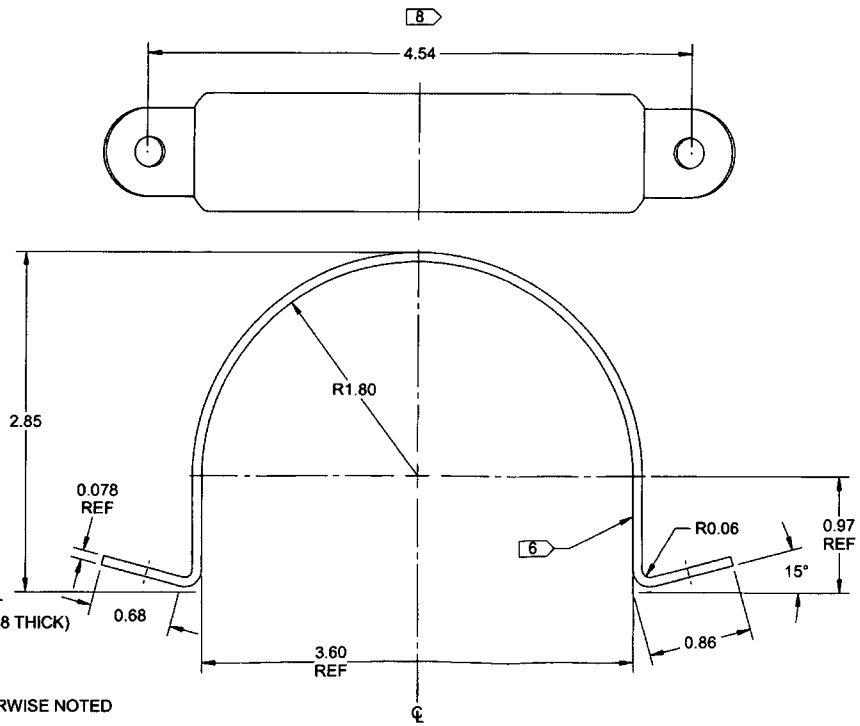
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____



D4799-1F CLAMP FLAT PATTERN





D4799-1 CLAMP
(MAKE FROM D4799-1F)

110127 MCJ
13-12-19

RELEASED
13.05.28
ECN 13.562

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316)
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.02 lbs
8) DIMENSIONED FROM BOTTOM SURFACE OF CLAMP

REV.	DESCRIPTION	BY	DATE
B	DECREASE LENGTH FROM 9.53 TO 9.16, ZN C5-1.	DC	13.05.07
A	NEW ISSUE	DC	13.03.21

DESIGN		DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4799	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	13.05.07		

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